

Date Thursday, 16/08/2007 10:31:03 AM  
 User Linda Lacelle

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE
Job Number	: 34002	Part Number	: D29321
Estimate Number	: 10831	Drawing Number	: D2932 REV C
P.C. Number	: N/A	Project Number	: N/A
This Issue	: 16/08/2007	Type	: MACHINED PARTS
Prsht Rev.	: NC	Drawing Revision	: C
First Issue	: N/A	Material	: N/A
Previous Run	: 33654	Due Date	: 31/08/2007
Written By	:	Qty:	10
Checked & Approved By	:	Um:	Each
Comment	: Est: B 00.06.26 New DWG rev, (mpp 2069) EC Est Rev:C As per Rev C 07-03-19 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101003	7075-T7351 2X6.25X7.875	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 Cut Size 2.0 x 6.25 X 7.880 Grain Along Long 7.88 Length Batch No: <u>33792</u>	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr & TUMBLE	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 07/07/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 16/08/2007 10:31:03 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, OUTBOARD, LEFT SIDE

Job Number: 34002

Part Number: D29321

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

MRK 07/09/06 10

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(10)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M.F.

07/09/06

7.0 POWDER COATING

POWDER COATING



(10)

m 165008

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL

07-09-07

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7/8/10

(10)

50

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7/8/10 X10

SP

(10)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MRK 07/09/11

Job Completion



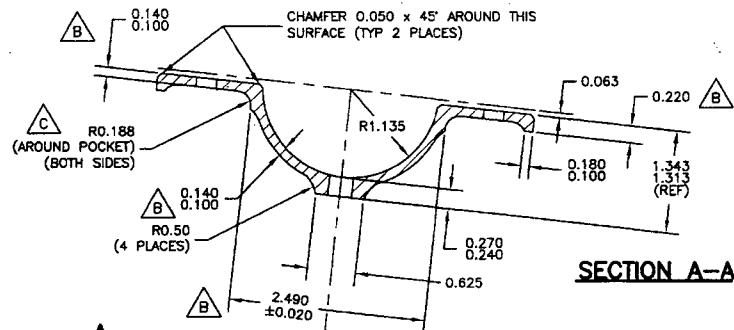
6/09/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

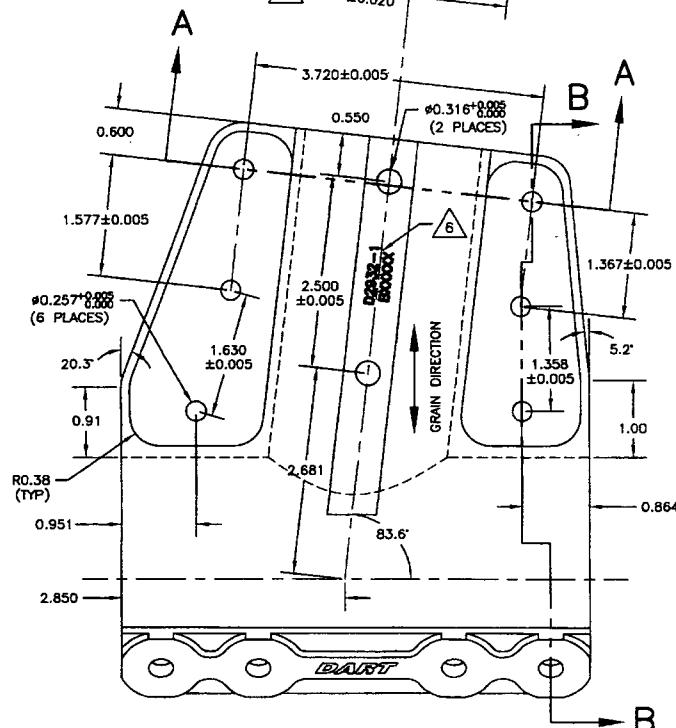
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

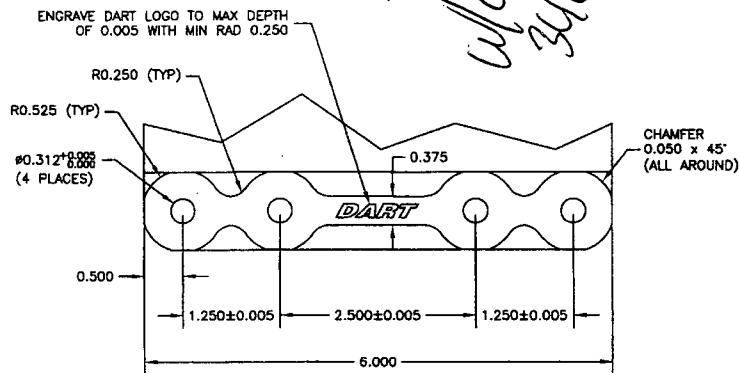
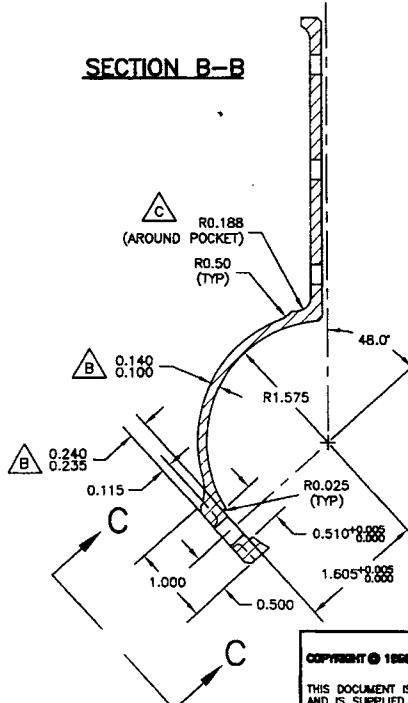
NOTE: Date & initial all entries



SECTION A-A



SECTION B-B



VIEW C-C

D2932-1 LH SADDLE (SHOWN)  
D2932-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. RELEASER CB BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. REV. C D2932 SHEET 1 OF 1
DATE	TITLE	SCALE 06.11.09 SADDLE OUTSIDE 2:3

RELEASED  
07.02.12

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DART AEROSPACE USA, INC.

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		.125	.125	.125	.125		
B	0.100	0.140		.125	.125	.125	.125		
C	0.100	0.140		.125	.125	.125	.125		
D	0.210	0.230		.225	.225	.225	.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.124	.124	.124	.124		
O	0.540	0.560		.549	.549	.549	.549		
P	0.490	0.510		.505	.505	.505	.505		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.496	2.496	2.496	2.496		
S	0.240	0.270		.255	.255	.255	.255		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.131	1.131	1.131	1.131		
Y	1.565	1.585		1.569	1.569	1.569	1.569		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>SG</i>
Date:	07.09.02

Audited by:	<i>JNL</i>
Date:	07/09/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD

Work Order:

Description: 206 Saddle, Outboard, Left side

Part Number: D2932-1

Inspection Dwg: D2932 Rev. C

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Dim	Min	Max	Go/No Go Gauge..	Recorded Actual Dimensions				By	Date
				X5	X6	X7	X8		
A	0.100	0.140		.125	.125	.125	.125		
B	0.100	0.140		.125	.125	.125	.125		
C	0.100	0.140		.125	.125	.125	.125		
D	0.210	0.230		.225	.225	.225	.225		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		.511	.511	.511	.511		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		.258	.258	.258	.258		
L	0.312	0.317		.314	.314	.314	.314		
M	0.235	0.240		.238	.238	.238	.238		
N	0.100	0.140		.124	.124	.124	.124		
O	0.540	0.560		.548	.548	.548	.548		
P	0.490	0.510		.505	.505	.505	.505		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		3.496	3.496	3.496	3.496		
S	0.240	0.270		.255	.255	.255	.255		
T	0.100	0.180		.135	.135	.135	.135		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		.320	.320	.320	.320		
X	1.125	1.145		1.131	1.131	1.131	1.131		
Y	1.565	1.585		1.569	1.569	1.569	1.569		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	<i>SG</i>
Date:	07.09.02

Audited by:	<i>Am</i>
Date:	07/09/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	

DART AEROSPACE LTD	Work Order:	
Description: 206 Saddle, Outboard, Left side	Part Number:	D2932-1
Inspection Dwg: D2932 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2932 Rev. C and record below:

Measured by:	<u>SG</u>	Audited by:	<u>and</u>
Date:	07.09.03	Date:	07/09/03

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	